

Work Order ID 64515



Page 1

Tuesday, December 07, 2010 10:02:13 AM

Item ID: D2989-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Basket Lid Assembly					
Start Date: 12/7/2010	Start Qty: 1.00		Cust Item ID:		
Required Date: 12/17/2010	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 12-7	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100 Large Fab 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989
A/R ER316 S.S. Rod Batch: 111585

*** PLEASE NOTE****

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
DSI9473

Pl 11-01-21

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

Memo

0.00

Pl 11-01-24 1 0 BE 11/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	12/17/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	0		

Subtotal

= 7 11/01/24

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Revision ID:
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Start Date: 12/7/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 12/17/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

5.11/01/25

141



Packaging

Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

0.00

used on 11/06/25

11/01/25

21

d

150



QC

Quality Control

D 350-607-043
QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/01/26

C 11/01/26

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Picklist Print

Tuesday, December 07, 2010 10:02:17 AM

Page 1

Work Order ID: 64515

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly



Start Date: 12/7/2010

Required Date: 12/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	11.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		11							
					63628	11							
D2506 Label Plate		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
					63254	5							
D2512-7 Rib		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
					62368	1							
D2581 Mounting Bracket		Manufactured	No			100	Each	15.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		15							
					61953	15							

Cpl 11.01.21

2
Cpl 11.01.21

B65279 → ①

Cpl 11.01.21

B63629 → ①

Cpl 11.01.21

B64425 → ②

W/O:		WORK ORDER CHANGES					
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Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 12/7/2010

Required Date: 12/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-13

Manufactured No

100 Each

2.0000

2



Rib

Location

Loc Qty

Loc Code

WA

2

63226

2

D2989-19

Manufactured No

100 Each

6.0000

2



Rib

Location

Loc Qty

Loc Code

WA

6

63630

2

63958

4

D3832-3

Manufactured No

100 Each

3.0000

1



Mesh (Lid)

Location

Loc Qty

Loc Code

WA

3

63234

3

D3833-3

Manufactured No

100 Each

7.0000

2



Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

7

46308

1

63053

6

Pl 11-01-21

B63957 → ②

Pl 11-01-21

②
Pl 11-01-21

①
②
Pl 11-01-21

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 64515

Parent Item: D2989-041









Parent Item Name: Basket Lid Assembly

Start Date: 12/7/2010

Required Date: 12/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3836-041	Manufactured	No	100	Each	1.0000	1		1	
									
Rib Assembly (Basket Lid, LH)									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			WA		1				
			63228		1				
D3836-042	Manufactured	No	100	Each	1.0000	1		1	
									
Rib Assembly (Basket Lid, RH)									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			WA		1				
			63229		1				
D3852-041	Manufactured	No	100	Each	1.0000	1		1	
									
Rib Assembly									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			WA		1				
			63230		1				
D3852-042	Manufactured	No	100	Each	1.0000	1		1	
									
Rib Assembly									
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
			WA		1				
			63231		1				

Pl 11.01.21

B64292 → ①

Pl 11.01.21

B64293 → ①

Pl 11.01.21

B64290 → ①

Pl 11.01.21

B64291 → ①

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Shop Packet Print

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69315
PS10-12-7

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL : LATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-11; D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D3827-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	<i>AJS</i>	D2989	SHEET 1 OF 5
MFG. APPR.	<i>AD</i>	TITLE	SCALE
APPROVED	<i>AD</i>	BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

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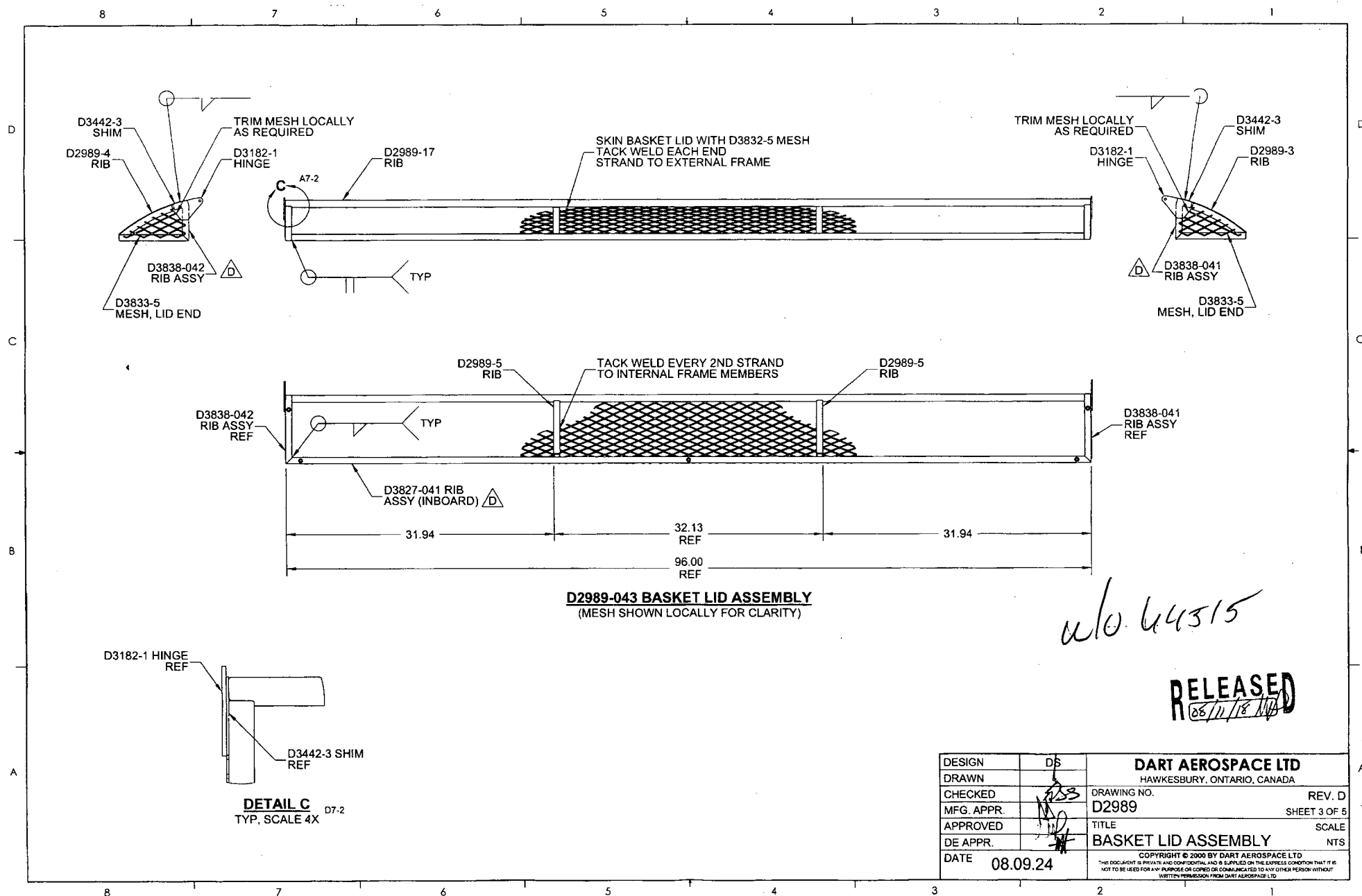
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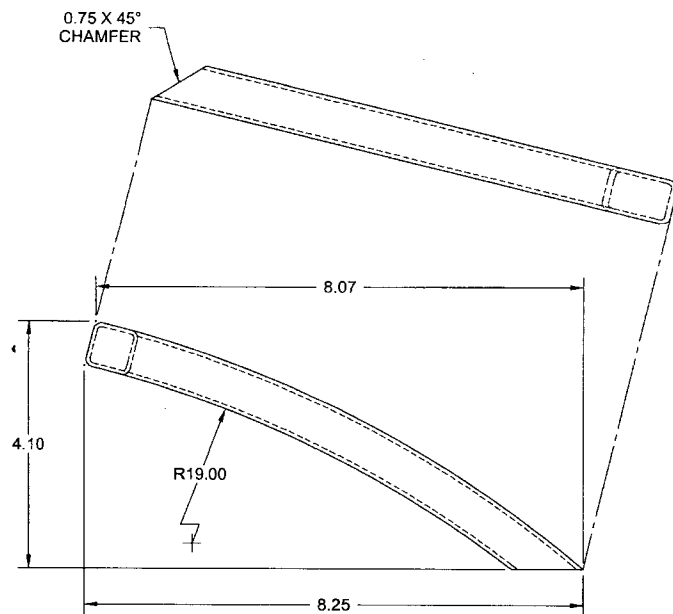
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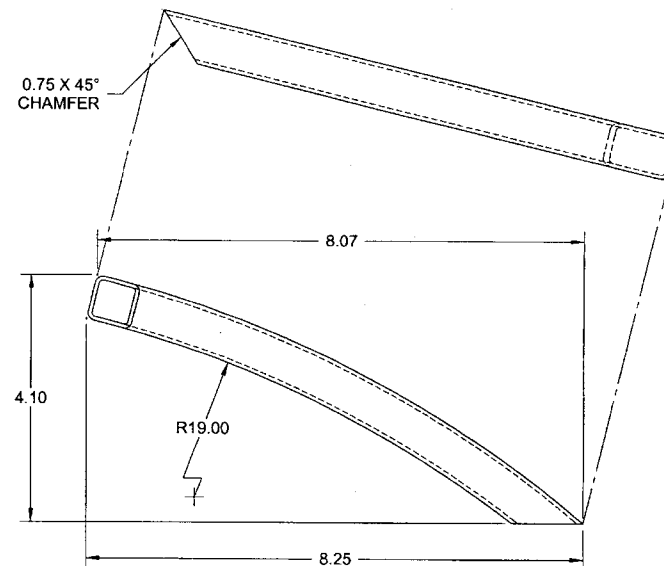
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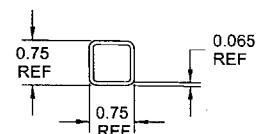
D2989-3 RIB



D2989-4 RIB

w/o 64575

RELEASED
08/11/18 NW



**TYPICAL SECTION
VIEW**

- NOTES:**
 1) MATERIAL: D3166-3 BASKET HOOP
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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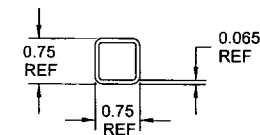
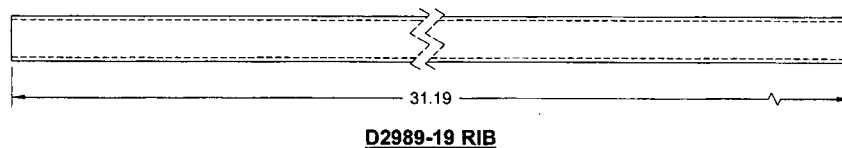
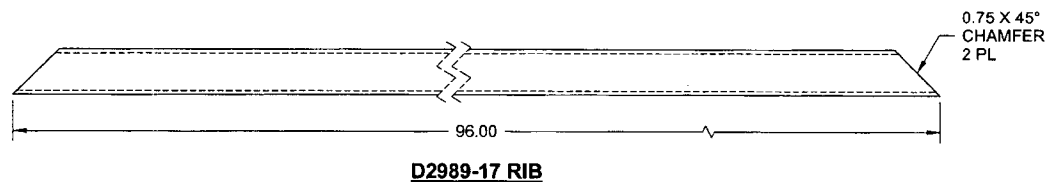
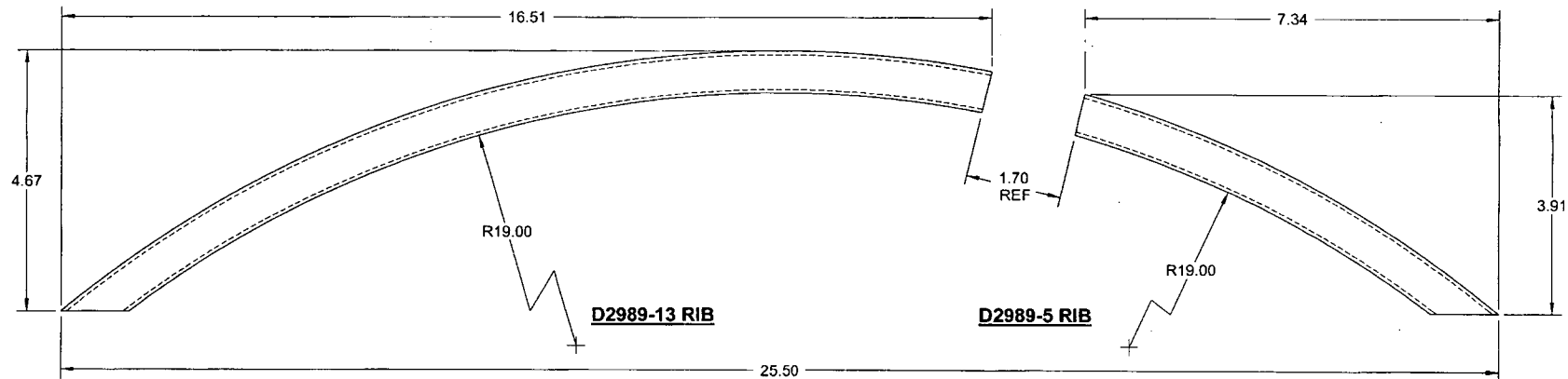
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TYPICAL SECTION VIEW

W/O 64515

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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